

NCL-19-7688



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6005G01631-3G-5**Job Sheet 198951**

DAS
21
9-89

Part No: RBW6005G01631-3G-5

Job Qty: 1 pcs

Part Name: Top Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/25/19

Type: SOLD

Description:

Note: DWG RBW6005G01631-3G Rev. A IPP Rev. A 18.09.25 New issue DP Verify DD/IPP Rev. B 19.01.11 drawing revision DP Verify DD

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	1		9/25/19	1.00	1.00	NV5000 - 1		J.C.L.
		pcs					NV5000 - 2		
110	QC 2	1		9/25/19	0.00	0.00	QC 2 - 1		J.C.L. 19-09-13
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

T
CE

S213674



G01631-3G-5

S213674

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/13/19



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
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TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S213674



Part No: RBW6005G01631-3G-5

Job No: 198951

Serial No/Batch: S213674

Revision: A

Sector:

Date:

Instructions:

Date: 09/13/19

Plex 8/8/19 9:30 AM Dart.lajeunesse.marie

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 Conventional Mill - 1 - B4B	1 pcs	9/25/19	0.00	1.00	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	Kt 19-09-22
130 QC 2	1 pcs	9/25/19	0.00	0.00	QC 2 - 1	Kt 19-09-22
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150 QC 8	1 pcs	9/25/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	

					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
185	Outsource - 4 - Anodize	1	9/25/19		GRO002-VC	
		pcs				
190	Packaging 2-1 - Receive - B4B	1	9/25/19	0.00 0.00	Packaging 2 - 1 - B4B	
		pcs			Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
200	QC 6	1	9/25/19	0.00 0.00	QC 6 - 9	
		pcs			QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
210	Packaging 3-1 - Stock - B4B	1	9/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	

19/9/22

2019-09-23

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	1 pcs	9/25/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-88

GA084

OCT 11 2019

Part Op 100 - 1-Machine as per folio FC 403 FOLIO REV: AA DWG REV: A 2-Debur
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - 1-Machine as per DWG. 2-Debur
 130 - QC2- Inspect parts off machine FAI/FAIB
 150 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 185 - -Issue P/O: 44582 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required
 190 - (Receive & Inspect for Damage & Mat'l Certs)
 200 - (QC6- All purchased or subcontracted products)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.000	6061-T6 Bar .750" x 1.00 <u>1.000 x 1.250</u>	.5400 ft (.54 ea)	100-NV5000 - 1	<u>5188 588</u>

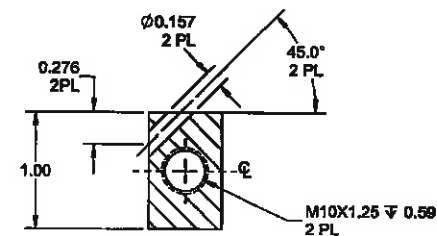
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	M6061T6B0.750X01.000 <u>1.000 x 1.250</u>	1	12	0

Part Specifications

Specifications could not be found.

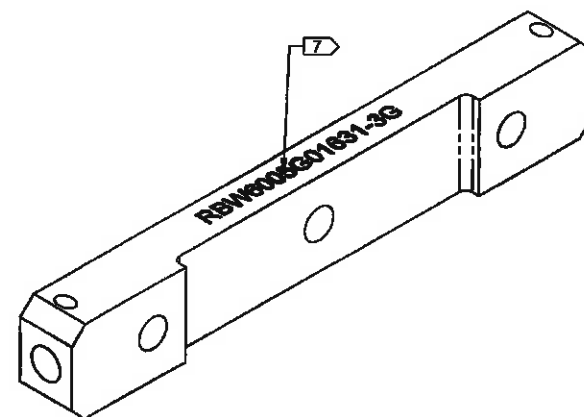
Plex 8/8/19 9:30 AM Dart.lajeunesse.marie



SECTION C-C



RBW6005G01631-3G-5 TOP CLAMP

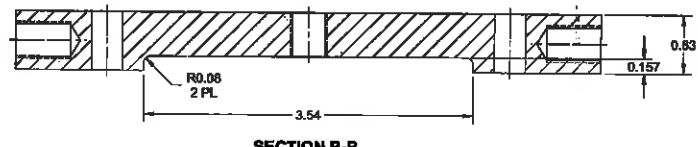
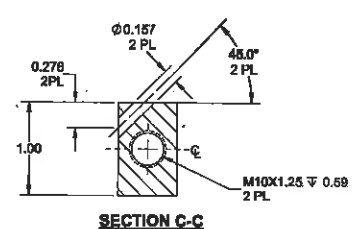
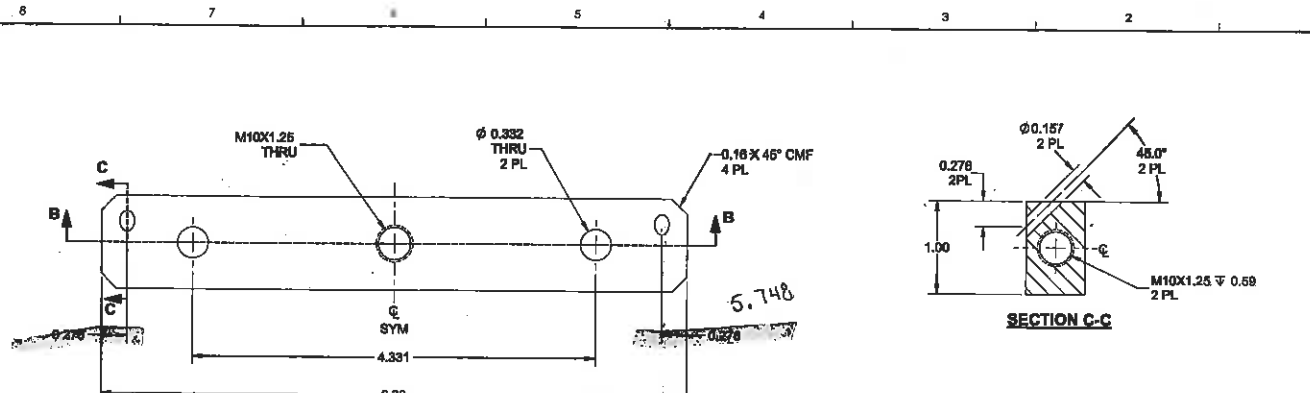


SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

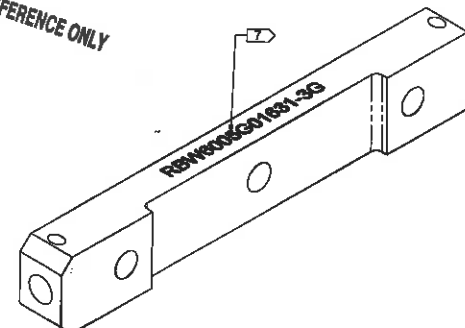
WITHOUT NOTICE
WORK ORDER
NO. 19895 MWS
19-0808

7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW8005G01631-3G	SHEET 6 OF 8
APPROVED	VP	TITLE	SCALE
		DIAL GAUGE (MR AWSH/F/SCISSORS) SUPPORT	NTS
DATE 8/31/2018		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OR OPERATIONS UNLESS SPECIFICALLY TO OUR OWNERS PERMITS WITHOUT VIOLATING OUR PATENT RIGHTS AND/OR TRADE SECRETS.	



REFERENCE ONLY



RBW6005G01631-3G-5 TOP CLAMP

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: XX = ± 0.1 " / ± 1 "
 XXX = ± 0.01 " / ± 0.5 "
 XXXX = ± 0.005 " / ± 0.1 "
 XXXXX = ± 0.0005 " / ± 0.05 "
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.006" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	ML	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6005G01631-3G	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DATE 9/20/2019		DIAL GAUGE (M/R AWSP/SCISSORS) SUPPORT	NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044562**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044562

PO Date: 9/23/19

Due Date: 10/1/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200255	RBE332A94-3400-03-10	Block -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$5.7692/pcs	\$34.62
2	198951	RBW6005G01631-3G-5	Top Clamp -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		10/1/19	4 pcs	0 pcs	4 pcs	\$5.7692/pcs	\$23.08

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Dart Aerospace Ltd.
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB044562



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197214	RB23003267-1	Clean Guide -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$5.7692/pcs	\$34.62
				X6			6107 7 0 130				DP
4	199123	RBT18608-5	Gauge -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		10/1/19	4 pcs	0 pcs	4 pcs	\$5.7692/pcs	\$23.08
				X4			OCT 0 2 2019				DP
5	195694	RB DB3182-1	Extension -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0505-00-1 Rev. 9 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$5.7692/pcs	\$34.62
				X6			OCT 0 2 2019				DP
Grand Total:											\$150.00



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER
POHB044562



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/19 1:01 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022670-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022670 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No		Bon de commande Client Customer Purchase Order No			
27-Sep-2019		Jigar Patel				POHB044562			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details		Description pièce(s)	CATG. U/M	Quantités / Quantities				
	Job # / Ref #				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBE332A94-3400-03-10 Rev.		RBE332A94-3400-03-10 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE-2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0
2	RBW6005G01631-3G-5 Rev.		RBW6005G01631-3G-5 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE-2 CLASS 2 WATER SEALANT	ANODIZE CH	4	4	0	0	0
3	RBE23003267-1 Rev.		RBE23003267-1 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE-2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0
4	RBT18608-5 Rev.		RBT18608-5 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE-2 CLASS 2 WATER SEALANT	ANODIZE CH	4	4	0	0	0
5	RB DB3182-1 Rev.		RB DB3182-1 01-ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0

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OCT 01 2019

DART AEROSPACE LTD.

RECEIVED

OCT 01 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: JK Date: Nov 1/19



NCR No. 19-7688 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>198951</u> Part No. <u>CLW6005601631-36-5</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>19/12/04</u>		Sequence #: <u>185</u>		QTY Affected: <u>3/4</u>		MRB (QSI042) <u>DAS 68</u> <u>9-89</u> OCT 08 2019			
Description Work Order Deviation				Disposition					
<u>Black contaminant found on parts.</u>				<u>- DOES NOT AFFECT THE FORM, FIT, NOR FUNCTION.</u>					
				Completed By <u>DAS 61</u> <u>9-89</u>					
				Lead hand / Supervisor <u>DAS 30</u> <u>9-89</u>					
				QC / QA Coordinator <u>DAS 68</u> <u>9-89</u>					
				OCT 08 2019					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☒ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							